

DART AEROSPACE LTD	Work Order:	24323
Description: Float Web	Part Number:	D3282-041
Dwg: D3282 Rev. C	Qty:	4
		Page 1 of 1

Step	Location	Procedure	Date	Qty
1	DC	Issue Traveler	05.09.26	4
2	LG	Cut to length as per Dwg D3282. Pick: Qty Part Number Description 1 D2792-130 Extrusion Identify as D3282-1	05-9-28	4
3	MV	Machine as per Folio FA579 & Dwg D3282	05.09.28	4
4	QC2	Inspect parts as they come off the machine	05-09-28	4
5	QC8	Second check	05/10/01	4
6	MV	Deburr	05.10.01	4
7	FP	Chemical Conversion Coat as per QSI 005 4.1	05-10-3	4
8	QC3	Inspect Chemical Conversion Coat	05-10-04	4
9	LG	Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web. Pick: Qty Part Number Description Batch 2 D3283-1 Doubler B24324 57 MS20470AD4-7 Rivet M15924 A/R N/A LPS-3 M17395 Identify as D3282-041	05-10-13	4
10	QC5	Inspect work to Step 9	05-10-17	4
11	ST	Identify and Stock in LG cell	05-10-17	4
12	AC	Cost / part: 136.17	05-10-18	4
13	DC	Close W/O 136.17 Inspect Level 21	05/10/18	4

Rev	Date	Change	Revised By	Approved
A	04.09.28	New issue	KJ/JLM	
B	05.09.23	Procedure change	KJ/JLM	

RELEASED
05.09.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

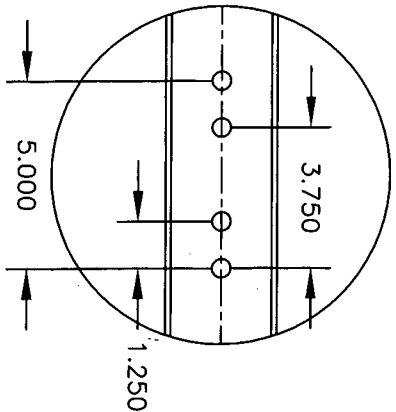
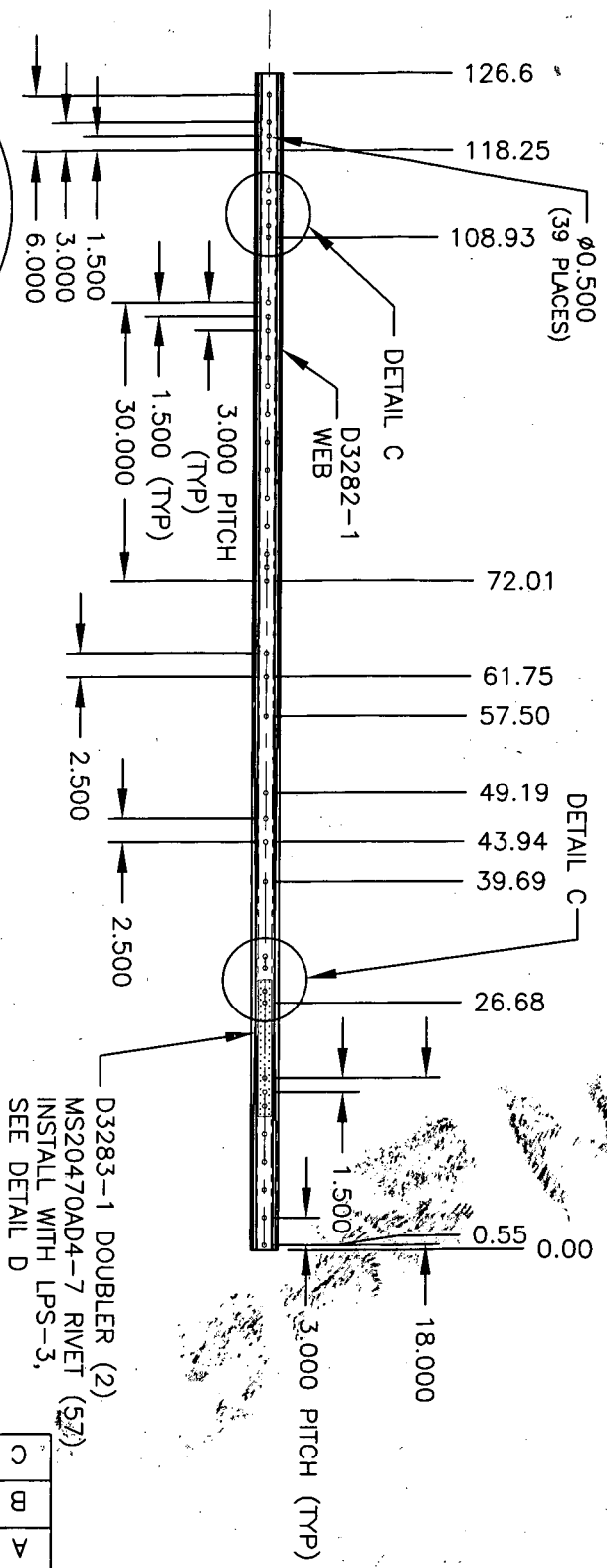
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/10/15

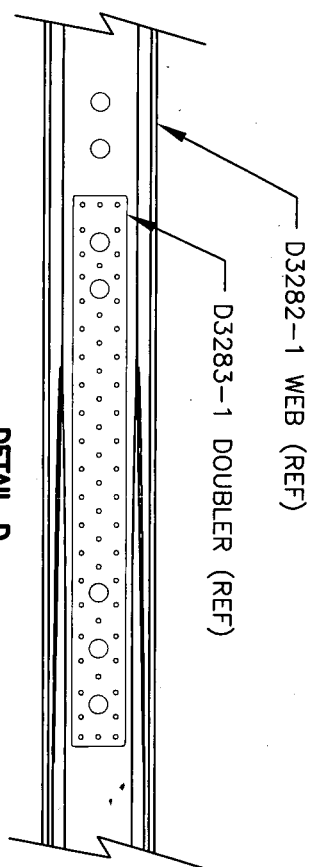
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE
05.08.26



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

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SUBJECT TO
WORK ORDER
NO. 24323

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS-LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

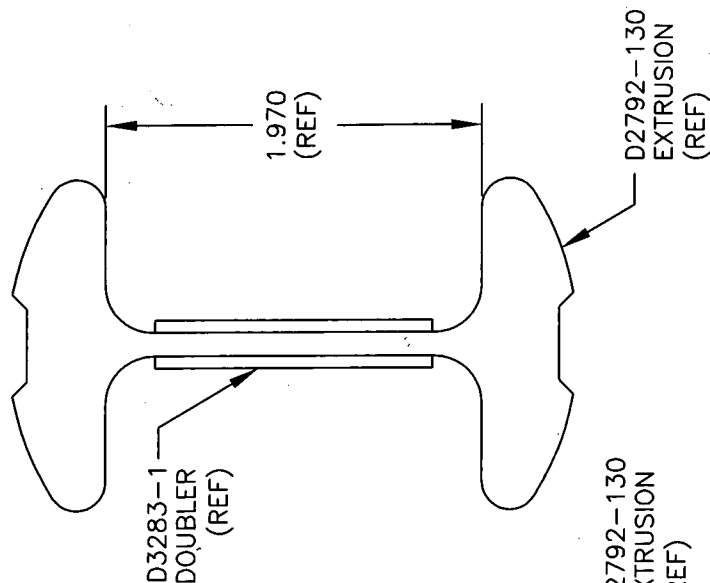
DESIGN	CP	CHECKED	APPROVED	DRAWING NO.	REV. C
DRAWN BY	CP			D3282	SHEET 1 OF 2
DATE	05.08.09				
TITLE	FLOAT WEB, 206L/407				
SCALE	1:20				
A	04.05.05	NEW ISSUE			
B	05.03.16	MOVE HOLES, ADD D3282-1 DOUBLERS			
C	05.08.09	REMOVE D3282-1, NOW MACHINED			

PRELIMINARY ISSUE

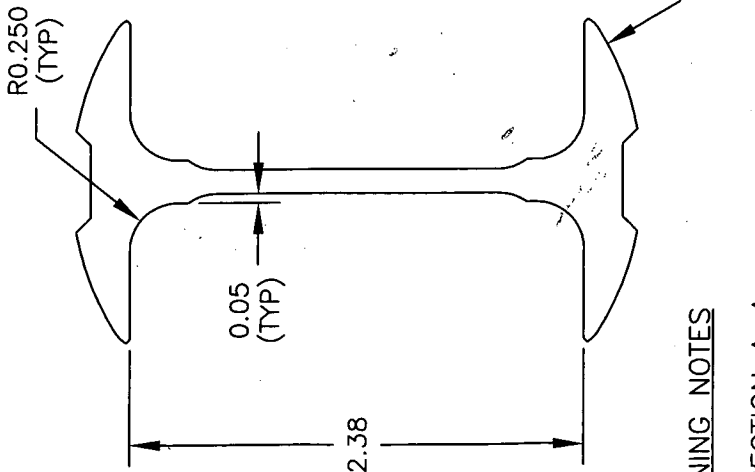
CP 05.09.26

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3282	REV. C SHEET 2 OF 2
DATE 05.08.09		TITLE FLOAT WEB, 206L/407	SCALE 1:20

SECTION B-B



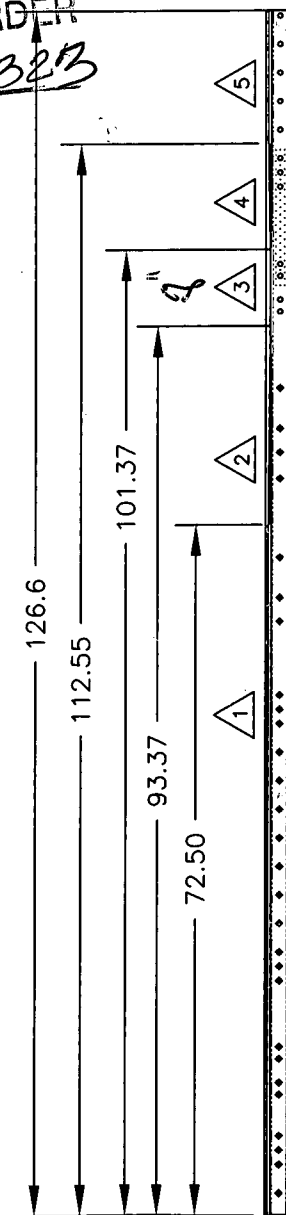
SECTION A-A



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS

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WORK ORDER
NO. 243213



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024323
Project Name : D3282-041
Project For : WK541
Work Order Type : Main
Main WO Number :
House Part Number : D3282-041
Description : I-Beam
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24323
Description: float web		Part Number: A3282-041
Inspection Dwg: A3282	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	± .100	126.563	✓		m-tape	
118.25	± .030	118.25	✓		"	
108.93	± .030	108.93	✓		"	
Ø.500	± .004 - .001	.502	✓		vern	
72.01	± .03	72.01	✓		m-tape	
61.75	"	61.75	✓		"	
57.50	"	57.50	✓		"	
49.19	"	49.19	✓		"	
43.94	"	43.94	✓		"	
39.69	"	39.69	✓		"	
26.68	"	26.68	✓		"	
.55	"	.55	✓		"	
18.000						
3.000pitch	± .010	2.999	✓		vern	
1.500	± .010	1.499	✓		vern	
2.500	± .010	2.499	✓		vern	
6.000	± .000	5.999	✓		vern	
3.000	2.999 ± .000	2.999	✓		vern	
3.750	± .010	3.749	✓		vern	
5.000	± .010	4.999	✓		vern	
1.250	± .000	1.249	✓		vern	

Measured by: J.C.	Audited by: ml	Prototype Approval:
Date: 05.09.28	Date: 05/09/28	Date: 05.09.30

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

